

Date: Wednesday 7/25/2007 12:19:52 PM
User: Kim Johnston

Process Sheet

SPLIT-2

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 33733
Estimate Number : 10113
P.O. Number : N/A
This Issue : 7/25/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : PURCHASED PARTS
Previous Run : 28216
Written By : 07.07.25
Checked & Approved By : 07.07.25
Comment : Est. A 24.03.04 New Issue KJ

Drawing Name : STEP EXTRUSION

Part Number : D2244116
Drawing Number : D2244 REV D1
Project Number : N/A
Drawing Revision : D1
Material : N/A
Due Date : 8/1/2007

Qty: 60 Unit: Each

Additional Product

Job Number:

Seq. #:

Machine Or Operation:

Description :

1.0

PG

PURCHASING

Comment: PURCHASING

Issue P/O: 4255

- a) Extrude as per Dwg D2244
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 116" long
- g) Caradon Indalex Tool # MH-18865
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

2.0

D2244116P

Step Extrusion

Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)

STEP EXTRUSION

3.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
Ensure certification are attached

4.0

QC6

DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK

Check Pull test per Dwg D2244 for compliance page attached.
Check hardness with Webster tester

(111) counted.

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP EXTRUSION

Job Number: 33733

Part Number: D2244116

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock (lin feet)

Location: 11A

7/10/11 SP
82

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(72)
7/10/11

Job Completion:



U 8/10/12

1870

1871

1872

1873

1874

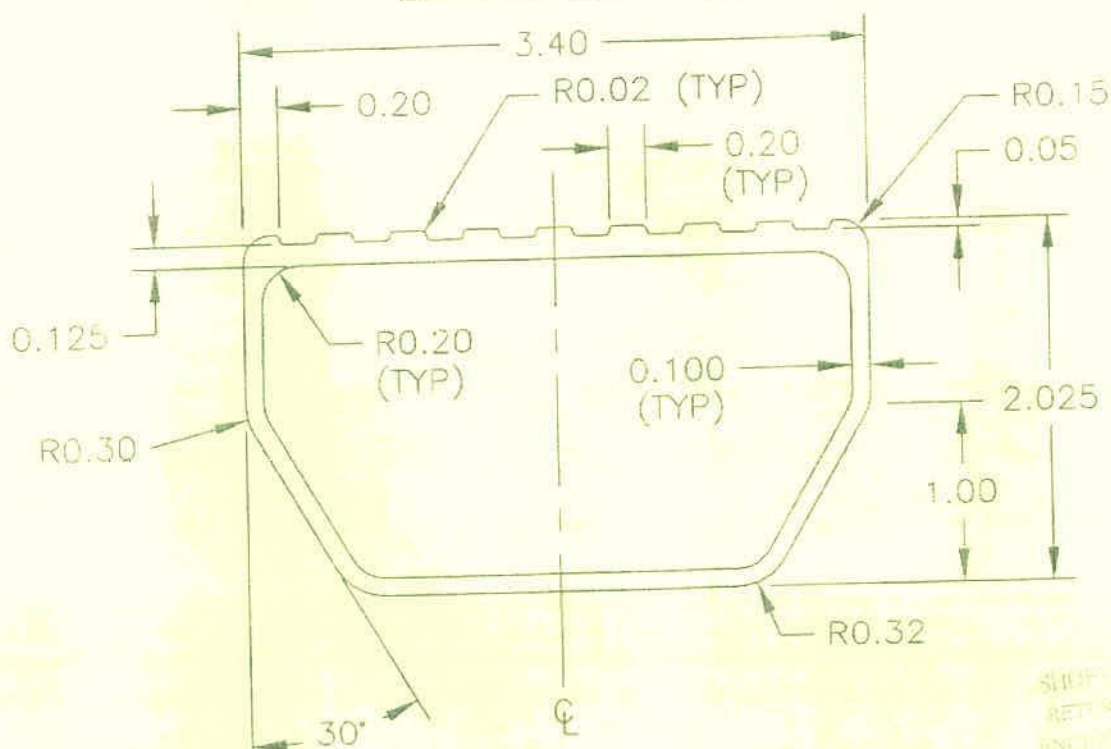
1875

1876



DESIGN BW		DRAWN BY <i>[Signature]</i>		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>		APPROVED <i>[Signature]</i>		DRAWING NO. D2244	
DATE 98.11.18		TITLE STEP EXTRUSION		REV. SHEET 1 OF 1 SCALE	
A	94.07.05	NEW ISSUE			
B	94.07.11	REDESIGNED			
C	94.08.08	REDESIGNED			
D	98.11.18	REMOVED 6005A MATERIAL INCORPORATED DEO 9081			
D1	01-04-17	ADDED DIE # <i>[Signature]</i>			

RELEASED
JUN 25 1964



MANUFACTURED USING CARBON INDEX DIE # MH-18865

PART NUMBER D2244-XX.X
XX.X IS CUT LENGTH IN INCHES

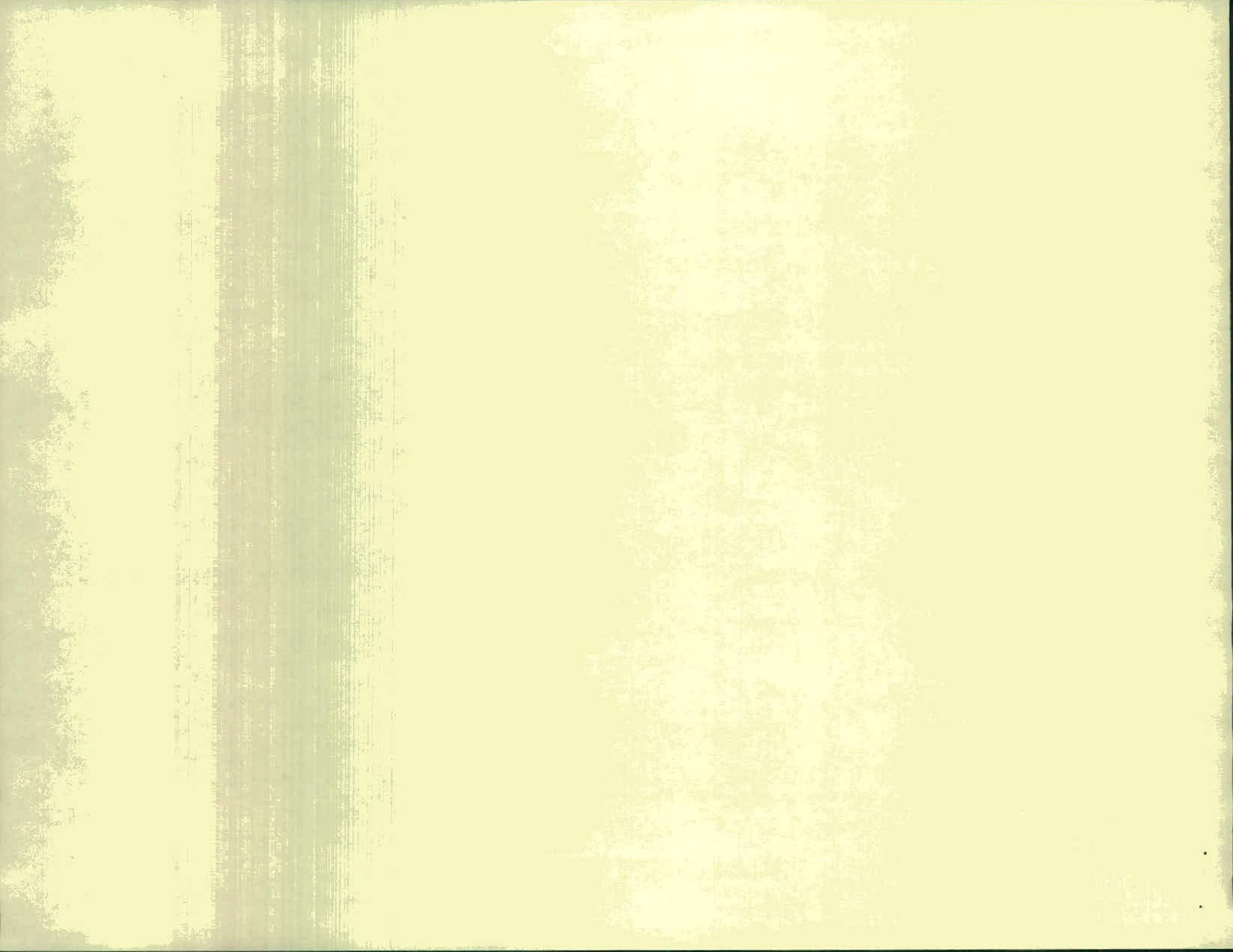
MATERIAL: 6061-T6 (QQ-A-200/8)

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHIRAZ
RETS
ENCLOSURE
UNCONTROLLED
SUBJECT TO
WITH
W/100
NO. 33



VENDU À / SOLD TO
DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ONT

EXPÉDIÉ / SHIP TO

INDICATIONS SPÉCIALES
SPECIAL INSTRUCTIONS

R/S: 617121
7072353 1

MÊME - SAME

K6A1K7

CUSTOMER P.S.T. : *6122-5207

INDALEX G.S.T. REG NO: R136834041

Required Date:

N° DU CLIENT CUST. NO.	T.P.S. G.S.T.	TAXE DE VENTE PROV. PROV. SALES TAX	N° DE COMM. DU CLIENT CUST. ORDER NO.	DATE DE COMMANDE ORDER DATE	NOTRE DATE DE COMM. OUR ORDER DATE	CONDITIONS TERMS
201355	XXXXXX		4253	7/07/25	7/07/25	
VENDEUR SALESMAN	EXPÉDIÉ PAR SHIP VIA	PAYÉ PPD.	PERC. COL.	C.A.D. C.O.D.	F.A.B. F.O.B.	EN BALLOTS BUNDLED AND TAPED
51	NOTRE CAMION OUR TRUCK	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
						CARTONNE CARTONED
						CARTONNE & INTERCALE CARTONED & INTERLEAVED

DATE DE LIVRAISON
DATE SHIPPED

7/08/09

ONTARIO 10 08 200'

QUANTITÉ QTY	COMMANDE ORDRE	PIÈCES PIECES	N° DE MATRIÈRE INDALEX DIE NO.	DESCRIPTION DU CLIENT CUSTOMER DESCRIPTION	ALLIAGE ET TREMPAGE ALLOY AND TEMPER	LONGUEUR LENGTH	PRIX UNITAIRE UNIT PRICE
				F EXTRUDE ONLY			
				DUE=2007/08/10 ASAP			
1	500	86	MH 18865 D2244	6061 T6	2946		
				STEP EXTRUSION			
				BUNDLE= 778194 ✓ 778202 ✓ 778204 ✓			
We hereby certify that the material supplied meets the chemical properties as published by the Aluminum Association, and requirements of our Quality procedures							
ISO 9001							

COMMANDE ORDRE	PIÈCES PIECES	BALLOTS BOLTS	PRIX PRICE	PIÈCES PIECES	MONTANT AMOUNT
0	0	3	645	111	POIDS EN KGS



325 rue Avro
Pointe-Claire QC H9R 5V3

Téléphone (514) 697-5120
Fac-simile (514) 694-8310

Rapport des propriétés mécaniques Mechanical Properties Test Report

Client / Customer : DART AEROSPACE LTD
Adresse / Address : 270 ABERDEEN STREET
HAWKESBURY ONT,
K6A 1K7

commande Indalex / Indalex order # : 7072353
bon de commande / Purchase order # : 4253
de matrice / Die # : MS 18865 Description : Step Extrusion
Alliage & trempage / Alloy & temper : 6061 T6
Contrôle / Control # : 53143-1
Coulée / Cast # : 41148

	Min.requis Min. required	Résultat actuel Actual results
Tension ultime Ultimate stress (psi)	38 000	41184 ✓
Contrainte élastique Yield stress (psi)	35 000	36497 ✓
% élongation dans 2" % elongation in 2"	8	12 ✓
Dureté Rockwell E (hre) Rockwell E Hardness (hre)	B: @ 100	90

Composition chimique typique / Typical chemical composition :

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti
6063	0,20 - 0,60	0,35 Max	0,10 Max	0,10 Max	0,45 - 0,90	0,10 Max	0,10 Max	0,10 Max
6005	0,60 - 0,90	0,35 Max	0,10 Max	0,10 Max	0,40 - 0,60	0,10 Max	0,10 Max	0,10 Max
6005A	0,68 - 0,72	0,15 - 0,27	0,08 - 0,12	0,20 - 0,24	0,48 - 0,52	0,03 Max	0,05 Max	0,03 Max
6061	0,40 - 0,80	0,70 Max	0,15 - 0,40	0,15 Max	0,80 - 1,20	0,04 - 0,35	0,25 Max	0,15 Max
6351	0,7 - 1,3	0,5 Max	0,10 Max	0,40 - 0,80	0,40 - 0,80	—	0,20 Max	0,20 Max

Nous certifions que le matériel fourni rencontre les exigences chimiques telles qu'annoncées par la norme ASTM B-221 excepté pour la section 8.2 (nombre de spécimen) et AMS QQA 200/8 excepté pour la section 4.2.3.1 (nombre de spécimen) qui sont déterminés par les exigences du client.

We hereby certify that the material supplied meets the chemical properties as published by the ASTM B-221 except for section 8.2 (number of specimen) and AMS QQA 200/8 except for section 4.2.3.1 (number of specimen) which is determined by customer requirement.

Sincèrement vôtre, date : 2007-01-03

Yours truly,

Mark Oliver Kokiong
Technicien de la qualité

Indalex Limited

